

Wednesday, 11/22/2006 1:40:01 PM

Kim.Johnston

SPL 07/01/19
SS

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING ASSEMBLY		
Job Number	: 29651					
Estimate Number	: 10716					
P.O. Number	: N/A			Part Number	: D3121241	
This Issue	: 11/22/2006		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Number	: D3121 REV D	
First Issue	: N/A		Type	: MACHINED PARTS		
Previous Run	: 27433			Project Number	: N/A	
Written By	: <u>W</u>			Drawing Revision	: D	
Checked & Approved By	: <u>W</u> 06/11/22			Material	: N/A	
Comment	: Est Rev:A 04.02.18 New issue KJ/DS			Due Date	: 11/29/2006	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"	
		Comment: Qty.: 0.0546 f(s)/Unit Total : 1.0920 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500) identify as D3121-25 Batch: M101827	06/11/22
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL	06/11/22
		1-Turn D3121-25 Cap as per Folio FA387	06/11/22
		2-Deburr	06/11/22
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	06/11/22
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	06/11/22
5.0	D312123	Bearing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number Description Batch	06/11/22
		1 D3121-23 Bearing 526936	
			12
			818

Process Sheet

Drawing Name: BEARING ASSEMBLY

Customer: CU-DAR001 Dart Helicopters Services

Job Number: 29651

Part Number: D3121241

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

Er/07/01/18

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

R 7/01/19 (14)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

R 07/01/19

Job Completion



U 07.01.19

DART AEROSPACE LTD	Work Order:	29651
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

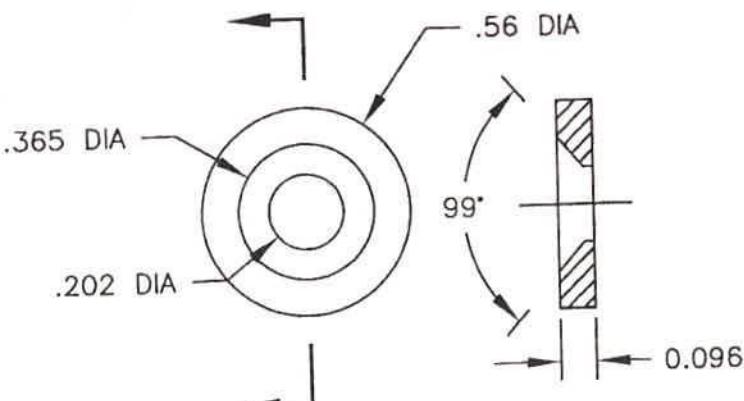
X First Article Prototype

Measured by: <u>JF</u>	Audited by: <u>EN</u>	Prototype Approval: <u>N/A</u>
Date: <u>05/15/27</u>	Date: <u>05/15/27</u>	Date: <u>N/A</u>

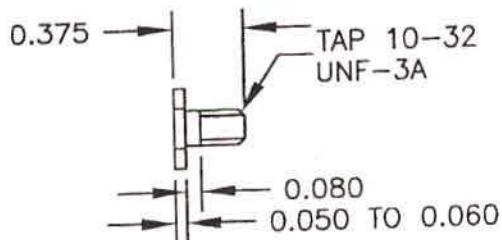
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	

DART

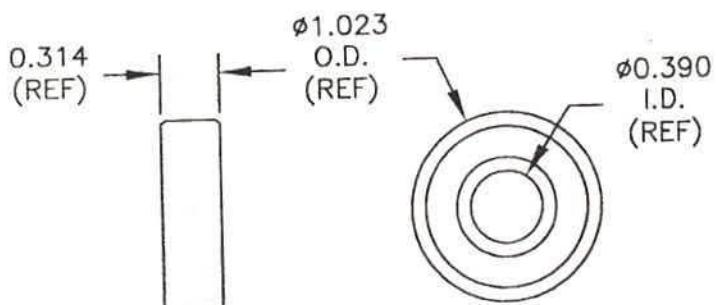
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKSLEY, ONTARIO, CANADA	REV. D
DATE		DRAWING NO.	SHEET 10 OF 10
06.05.17		D3121	SCALE
		TITLE	1:1
		BRACKET ASSEMBLY	

**D3121-17 WASHER (SCALE 2:1)**

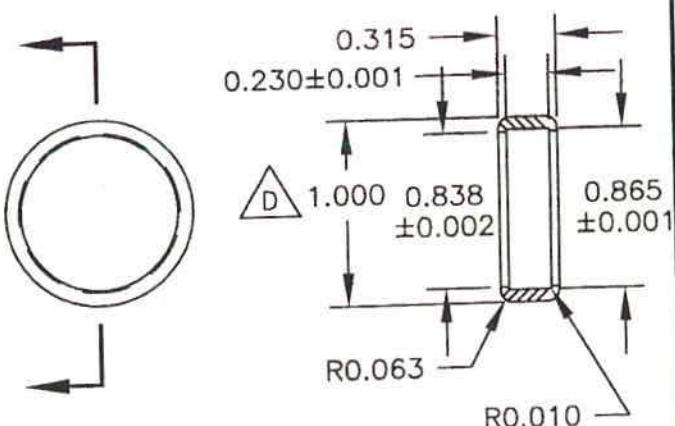
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-21 BOLT (SCALE 1:1)**

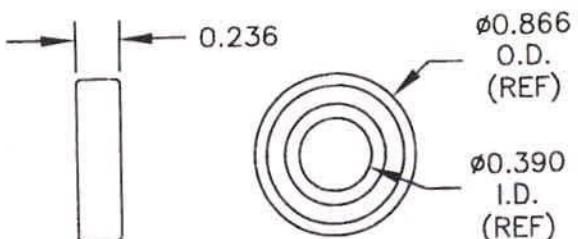
- 1) MATERIAL: AISI 303 SS HEX (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

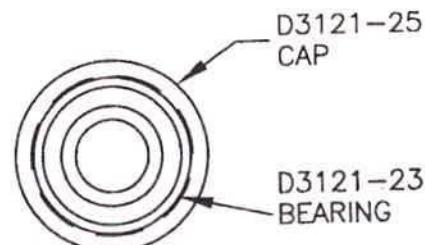
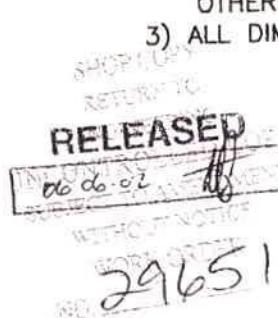
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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